








# Work Order ID 64790

Friday, December 17, 2010 7:55:03 AM


Page 1

Item ID:	D3637-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket Assembly				Stop	
Start Date:	12/16/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>PK</u>	Date:	<u>10-12-17</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3637	Rev B								


100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3637 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
364 .0810	Deburr if necessary								

B10-12-38

(11)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B10-12-38

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

S 11/11/03

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64790**

Friday, December 17, 2010 7:55:03 AM

Page 2

Item ID: D3637-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 12/16/2010 Start Qty: 8.00

Required Date: 1/19/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3637

0.00

0.00

SP 11/01/04

(11)

140



Small Fab

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT8979 □ 2-C'Sink as per Dwg D3637 □ 3-  
Install Nut plate as per Dwg D3637

0.00

0.00

⇒ m-d 11/01/05

(11X)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/01/05

(X1)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 64790**

Friday, December 17, 2010 7:55:03 AM



Page 3

Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/16/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: **246A**

0.00



Packaging

Memo

0.00

Packaging

*[Signature]* 11/01/06 (11)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*[Signature]* 11/01/06  
C 11/01/06

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 7:55:07 AM

Page 1

Work Order ID: 64790

Parent Item: D3637-041

Parent Item Name: Bracket Assembly



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC  
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20426AD3-3 Purchased

No

100

Each

3,847.000

2

16



Rivet

Location

Loc Qty

Loc Code

ST316

3847

19099 ✓

3847

M304S14GA

Purchased

No

140

sf

77.4108

0.09

0.757895

1.5



304SS sheet .080

Location

Loc Qty

Loc Code

MAT20

77.4108

113295

77.4108

MS21059L4

Purchased

No

140

Each

28.0000

1

8



Nutplate

Location

Loc Qty

Loc Code

ST301

28

114718 ✓

28

m-l 11/01/05

22 x  
180-12-28

(11)

113295

m-l 11/01/05

11 x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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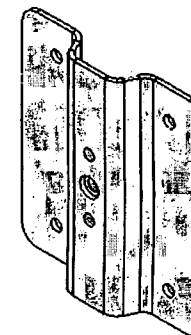
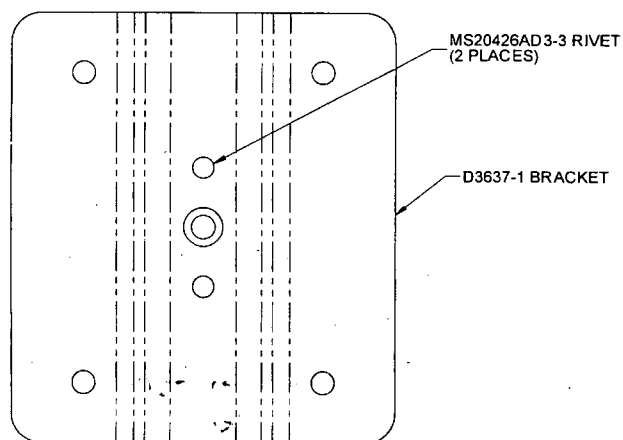
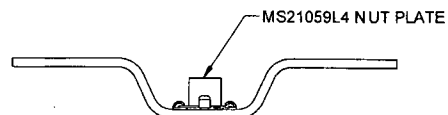
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69790  
21012-17

**D3637-041 BRACKET ASSEMBLY**  
(WAS GENEVA P/N G10602-1)

**D3637-041 PARTS:**

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

**D3637-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

RELEASED  
2002-05-10

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	PH		
MFG. APPR.	ED		
APPROVED	MD		
DE APPR.			
DATE	07.12.18		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. B	
D3637		SHEET 1 OF 3	
TITLE		SCALE	
BRACKET		1:	
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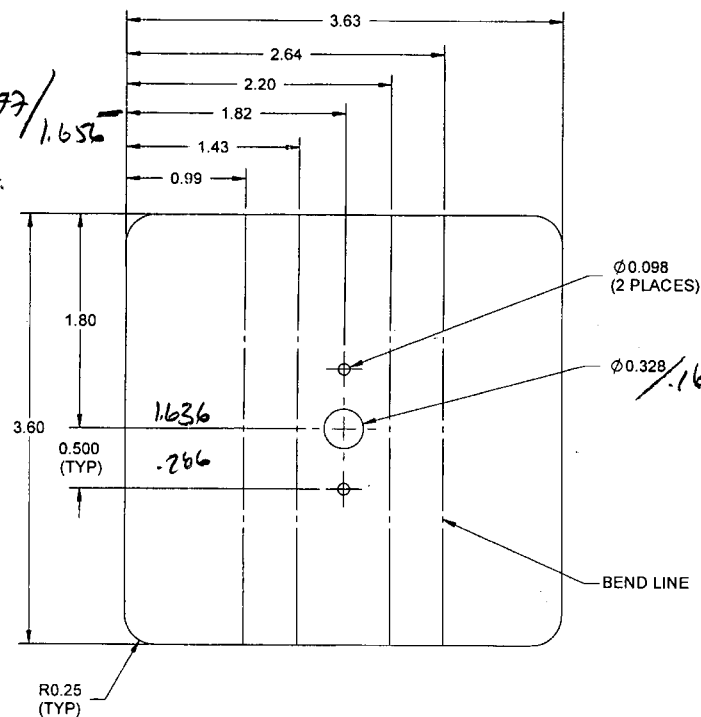
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

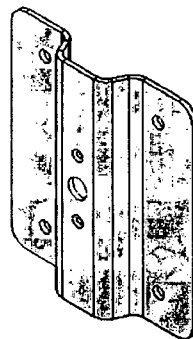
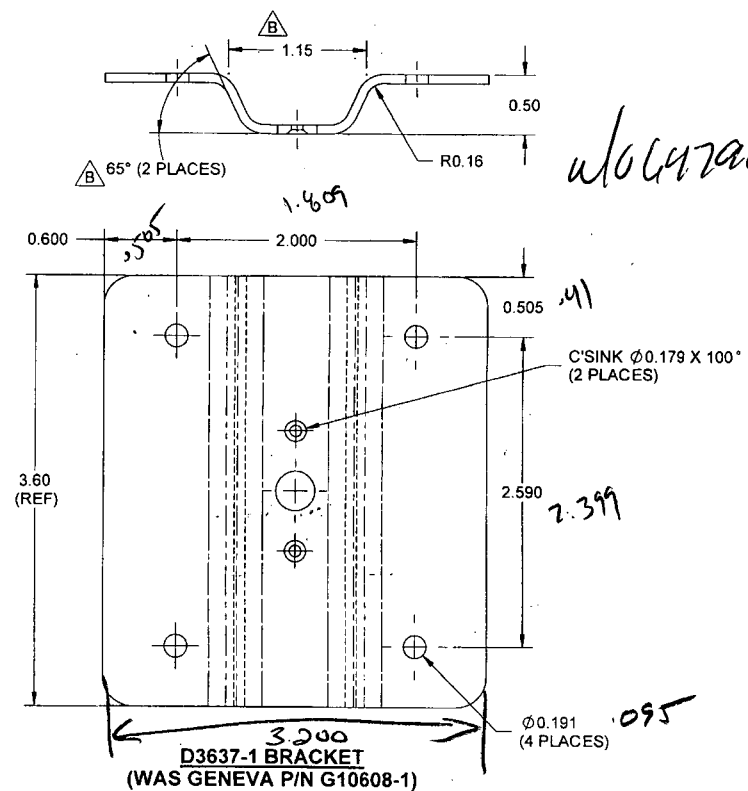
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**NOTE:** Date & initial all entries







**D3637-1F FLAT PATTERN**



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059  
(REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3637	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	1:1
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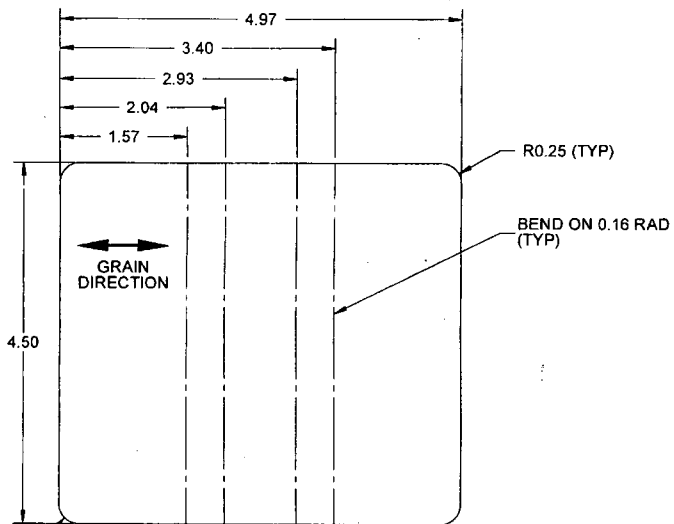
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

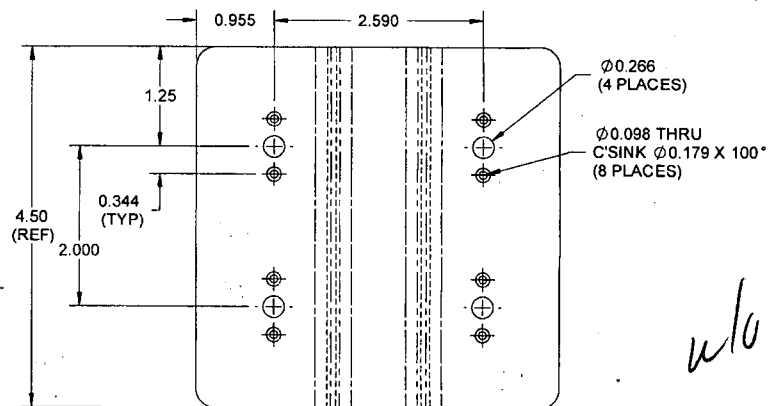
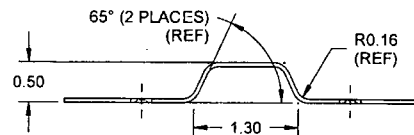
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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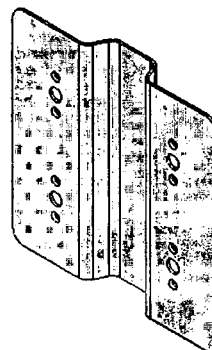
**NOTE:** Date & initial all entries



**D3637-3F FLAT PATTERN**



**D3637-3 BRACKET  
(WAS GENEVA P/N G10609-1)**



**D3637-3 NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Pet	DRAWING NO.	REV. B
MFG. APPR.	GP	D3637	SHEET 3 OF 3
APPROVED	NY	TITLE	SCALE
DE APPR.	NY	BRACKET	2:3
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